

Work Order ID 78644

January-12-12 7:50:54 AM

78644

Page 1

Item ID: D206-642-151

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Replacement Skidtube

Start Date: 12/01/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 26/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.C.J.

Date: 12/01/12 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3804	A								
IIN-D206-642	O								

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

[Handwritten signature]

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR: Yes No** **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 26/01/2012 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
1-10									
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804								
	3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.								
	Pick:								
	Qty Part Number Description Batch								
	A/R Aluminum Rod <i>m119785/m119712</i>								
	4-Grind weld flush to cap on top surface only.								
	5-Cut Aft end as per dwg D3804 from front of tube and Deburr								
	6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804								
	7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.								
	8-Drill pilot holes using Dt8166 & DT8169D & DT9771.								
	9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.								
	10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.								

2 SAP 12-01-12

3 DE 12-01-12

12 12/01/17

2 SAP 12-01-17

12 12/01/18

W/O:		WORK ORDER CHANGES					
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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.
****no wearplate holes for this skidtube****

17-Deburr tube and blow out chips from inside the tube

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

8/12/01/12

DL 12/01/18

(70)

Dart Aerospace Ltd

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

① ~~Ø~~ CF 12-1-18
DL

① ~~Ø~~ SAD 12-01-18

DL 12/01/18

Dart Aerospace Ltd

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

QC6- Inspect dimensions to drawing

0.00

170

QC

Memo

0.00

Quality Control

1 0 BE 12-01-18

180

Skidtubes

0.00

180

Skidtubes

Memo

0.00

Skidtubes

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12

Hrs. cure time before cutting

Start Date: 12/01/18 Time: 15:30

Finish Date: 12/01/19 Time: 11:00

Pick:

Qty Part Number Description Batch

A/RSikaflex-291 M119508

Sikaflex expire date: 2012/08/13

> 1 SAD 12-1-18
CF SAD 12-1-18

Dart Aerospace Ltd

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									

1 0 360/01/19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Skidtubes	0.00							
200									
Skidtubes		0.00							
Skidtubes	<div><div>Memo</div><div>1-remove alodine from around hole and prepare for welding</div><div>2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.</div><div>Pick:</div><div>QtyPart NumberDescriptionBatch</div><div>A/RAluminum Rodm119785</div><div>3-Grind welds flush as per Dwg D3804.</div><div>4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.</div><div>A/RSS RodNDVE</div><div>5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr</div></div>								

BE 12-01-19

BE 12/01/19

BE 12-01-20

DP 12-1-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
210	HandFinish	0.00							
Hand Finishing	Memo Install D2680-041 Nut Plate as per Dwg D3804								
215	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
215	QC	0.00							
Quality Control	Memo								
220	QC10- Inspect visual per QSI004- ground welds	0.00							
220	QC	0.00							
Quality Control	Memo								

① JB 12/01/12

12.01.23

8/21/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							
230		0.00							
QC	Memo	0.00							
Quality Control									
240	Pressure Wash per QSI005 4.3	0.00							
240		0.00							
HandFinish	Memo								
Hand Finishing									
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
250		0.00							
Powdercoat	Memo								
Powder Coating									

W129480

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30
320°F
10:00

12/01/24

12/01/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Run Start ***NR1***

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Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

260

QC3- Inspect Part Finish

0.00

260

QC

Memo

0.00

Quality Control

1 hr d M 12/01/26

270

HandFinishing

0.00

270

HandFinish

Memo

0.00

Hand Finishing

1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.

1 hr d M 12/01/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	HandFinishing	0.00							
280									
HandFinish	Memo	0.00							
Hand Finishing	1- Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/RSikaflex-291 <u>14119508</u> Sikaflex expire date: <u>12/6/08</u> 2- Install wearplate as per dwg 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: <u>1412012</u>								
290	QC3- Inspect Part Finish	0.00							
290									
QC	Memo	0.00							
Quality Control									

8 12/01/30

14/12/12 d M 12/01/26

Dart Aerospace Ltd

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300 *300* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		12/01/30					
310 *310* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D206-642-151 Location: _____ PPP Rev: _____	0.00 0.00		PPH 62682					12/2/25p
320 *320* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							M.L.J 12/02/03

Handwritten signature

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC IPP
REV:B 11.09.16 PER IIN REV.O DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2620		Manufactured	No			110	Each	18.0000	1	1			
D2620													
Skidtube, 206 Skidtube													

**

SAD 12-01-12

Location

Loc Qty

Loc Code

LG

18

71616

1

71617

6

75587

2

76815

1

76817

5

76819

3

2817

D2647

Manufactured No

110

Each

158.0000

1

1

D2647

Cap

**

BE12-01-12

Location

Loc Qty

Loc Code

LG002

158

73826

49

75482

109

1

W/O:		WORK ORDER CHANGES					
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78644

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-04

Purchased

No

180

Each

11,453.00

52

52

CR3212-4-04

Cherry Rivet

**

~~SAD~~ 12-01-18

Location

Loc Qty

Loc Code

ST331

1463

116471

78

117816

3

118686

1

118840

16

119017

1355

119075

10

st510

9990

119075

9990

32 C 12.1.18

D2654-1

Manufactured

No

180

Each

13.0000

1

1

D2654-1

Web

**

Location

Loc Qty

Loc Code

LG

13

76756

5

76757

2

76758

6

D3286-1

Manufactured

No

180

Each

126.0000

2

2

D3286-1

Doubler

**

77278

12.1.18

12/01/18

Location

Loc Qty

Loc Code

LG002

128

74872

6

75484

4

ST046

-2

76772

116

2

January-12-12 7:50:58 AM

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Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

January-12-12 7:50:58 AM

Work Order ID: 78644

78644

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2649 Manufactured No 200 Each 580.0000 19 19

D2649

Cross Bolt Spacer

BE 12-01-19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	400	
77574	400	<u>19</u>
LG001	180	
65317	1	
68224	2	
68507	11	
71355	2	
72704	2	
72841	11	
73390	8	
73857	21	
73858	53	
73859	4	
73860	4	
76793	61	

D3286-3 Manufactured No 200 Each 170.0000 2 2

D3286-3

Spacer

BE 12-01-20

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	100	
78015	100	
LG001	70	
74117	1	
76773	69	<u>2</u>

January-12-12 7:50:58 AM

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Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 78644

78644

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041 Manufactured No

210 Each 135.0000 1

D2680-041

Nut Plate

**

1 ~~12/01/12~~

Location Loc Qty Loc Code

ST013 39

75479 39

ST019 96

76790 96

CR3212-4-03 Purchased No

210 Each 1,706.000 2

CR3212-4-03

Cherry Rivet

**

2 ~~12/01/12~~

Location Loc Qty Loc Code

FP002 716

114859 716

ST331 990

110139 2

119017 988

AN960JD416 NAS1149D0463J Purchased No

210 Each 0.0000 1

AN960JD416

Washer

**

11118384 (v1) 12/01/12

CCR264SS3-3 Purchased No

210 Each 937.0000 2

CCR264SS3-3

Cherry Rivet

**

2 ~~12/01/12~~

Location Loc Qty Loc Code

ST331 937

113973 2

117849 139

119017 796

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

January-12-12 7:50:58 AM

Work Order ID: 78644

78644

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

296.0000

1

1

MS27039-4-06

Screw

**

(v1) M 12/01/2012

Location

Loc Qty

Loc Code

ST292

296

119075

296

D2651-1

Manufactured

No

270

Each

177.0000

6

6

D2651-1

Plug

**

1377559(x6) M 12/01/2012

Location

Loc Qty

Loc Code

FP001

177

57869

1

66445

10

69018

2

70839

2

71037

31

73827

131

D2651-3

Manufactured

No

270

Each

2,667.000

6

6

D2651-3

O-Ring

**

M 12/01/2012

Location

Loc Qty

Loc Code

FP001

667

61962

12

73828

655

x 6

FP-A

2000

78126

2000

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 78644

78644

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1 Manufactured No

280 Each 775.0000 14 14

D3873-1

Bushing

**

u 12/01/26

Location

Loc Qty

Loc Code

ST088

775

64760

1

68247

4

73829

19

73830

2

76792

249

78017

500

x14

D2646 Manufactured No

280 Each 119.0000 1 1

D2646

Aft Cap

**

u 12/01/26

Location

Loc Qty

Loc Code

FP002

119

62678

5

68280

5

70945

1

71038

4

71070

2

73294

1

73825

101

x1

D3805-041 Manufactured No

280 Each 9.0000 1 1

D3805-041

Wearplate Assembly Fwd, Low Gear

**

B76777(x1) u 12/01/26

Location

Loc Qty

Loc Code

FP001

9

75488

6

75489

3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 7

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Work Order ID: 78644

78644

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,037.000

2

2

MS27039-1-08

**

JL 12/01/26

Screw

LocationLoc QtyLoc Code

ST291

1037

117423

77

118910

86

119075

374

119109

500

x2

MS21042L3

Purchased

No

280

Each

6,081.000

7

7

MS21042L3

**

JL 12/01/26

Nut

LocationLoc QtyLoc Code

ST300

6081

117441

16

117885

32

118451

5

118927

3

119017

5551

119075

474

x2

D3805-045

Manufactured

No

280

Each

10.0000

1

1

D3805-045

**

D76786 x2 JL 12/01/26

Wearplate Assembly Aft, Low Gear

LocationLoc QtyLoc Code

FP001

10

73817

1

74896

1

76783

8

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

AN960JD10L

**

M119042 x2 JL 12/01/26

Washer

January-12-12 7:50:58 AM

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Page 7

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

Page 8

January-12-12 7:50:58 AM

Work Order ID: 78644

78644

Parent Item: D206-642-151

D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 12/01/2012

Required Date: 26/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No

280

Each

1,371.000

7

7

AN3-37A

Handwritten: 12/01/2012

Bolt

Location

Loc Qty

Loc Code

ST353

1371

117619

4

119086

1367

NAS1149D0363J Purchased No

280

Each

3,266.000

7

7

NAS1149D0363.J

Handwritten: 12/01/2012

Washer

Location

Loc Qty

Loc Code

ST298

3266

117601

61

118077

1

118612

18

118968

26

119537

1160

120142

2000

Handwritten: X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURNED
ENGINEER'S
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78644-M.C.O
12/01/12

RELEASED
09.07.07
per ECN 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	91		
DRAWN	91		
CHECKED	91		
MFG. APPR.	91		
APPROVED	91		
DE APPR.	91		
DATE	08.07.07		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3804	SHEET 1 OF 5
TITLE	SCALE
SKIDTUBE ASSEMBLY, 206A/B	NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

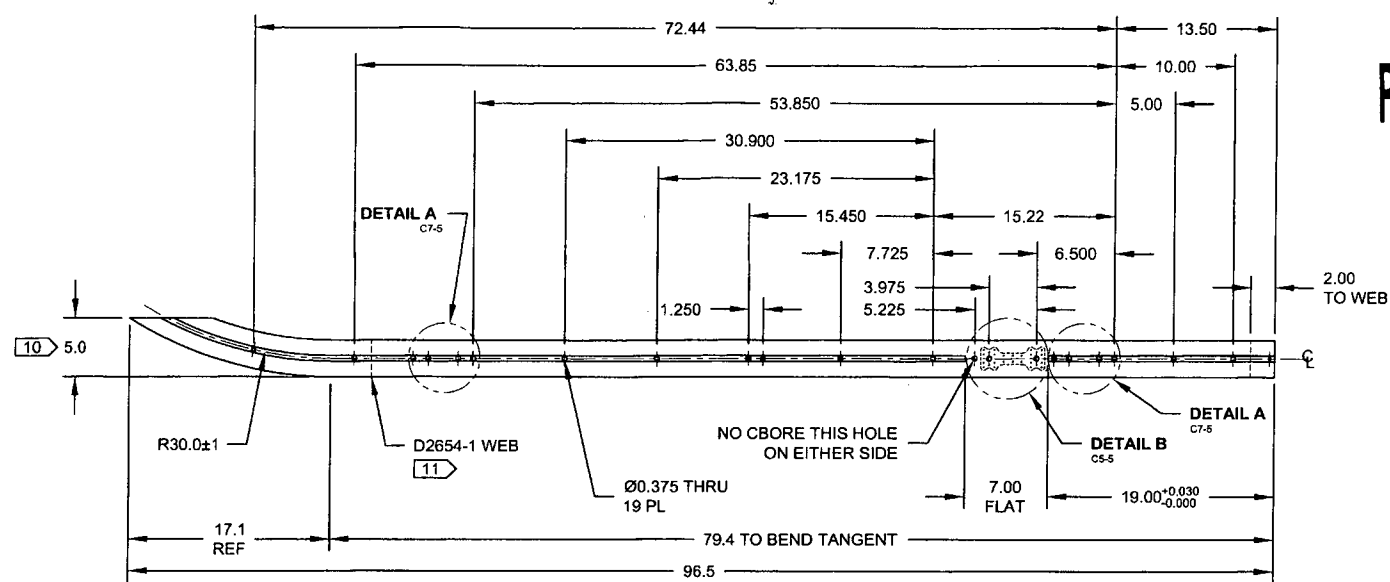
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

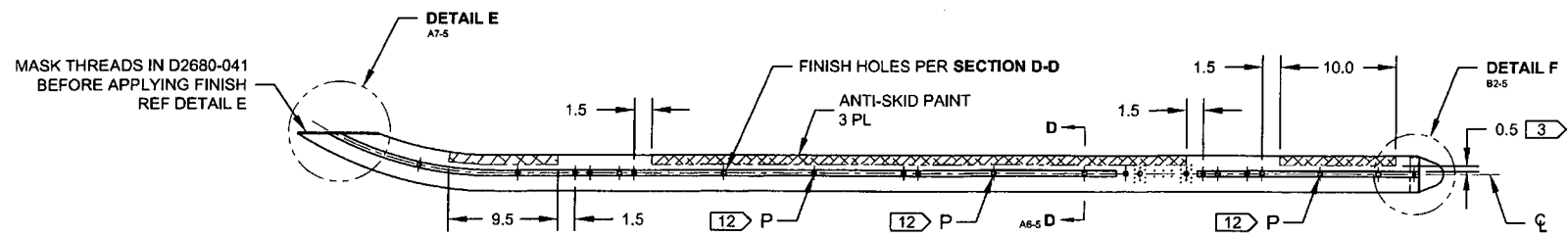
NOTE: Date & initial all entries

78644

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	99	PORT HADLOCK, WA	
CHECKED	99	DRAWING NO:	REV. A
MFG. APPR.	99	D3804	SHEET 2 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

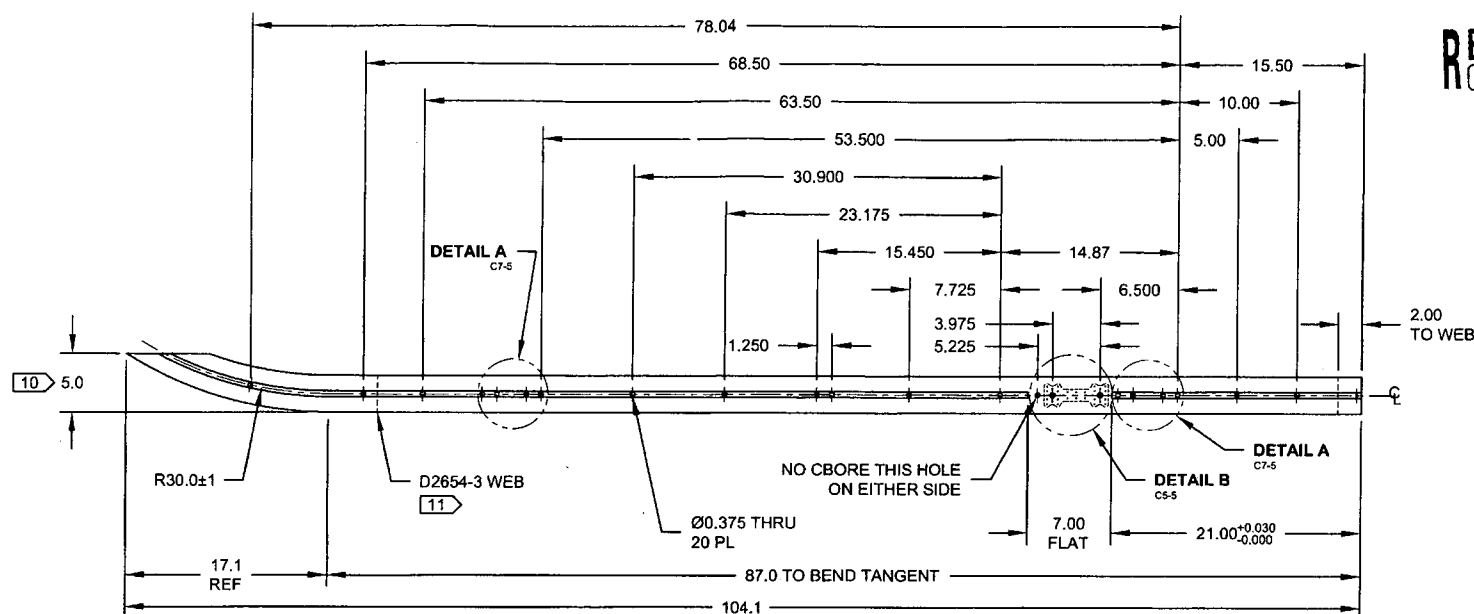
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

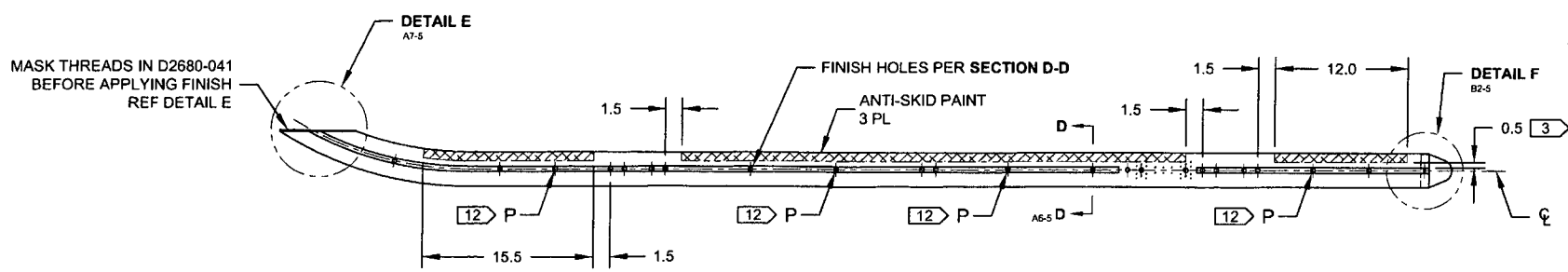
NOTE: Date & initial all entries

78644

RELEASED
(P 09-03-03)



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

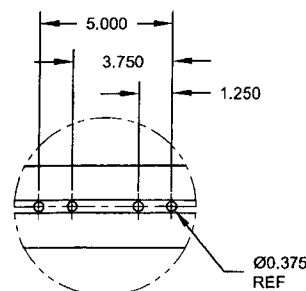
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

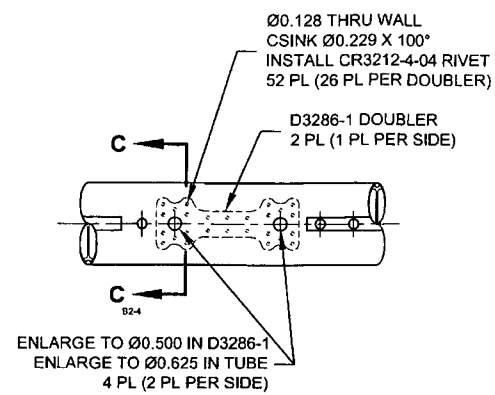
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70644

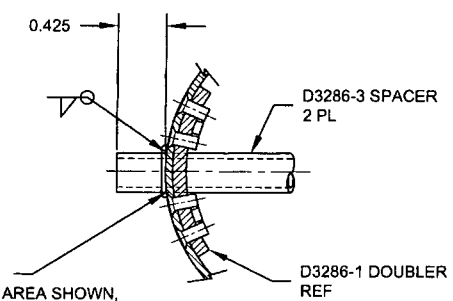
RELEASED
UP 09.03.07



DETAIL A
D6-2
C2-2
D5-3
C2-3
SCALE NONE

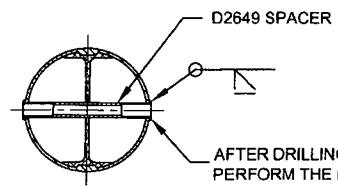


DETAIL B
C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C
C6-4
PARTIAL SECTION
SCALE NONE



SECTION D-D
A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	1	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 4 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
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Dart Aerospace Ltd

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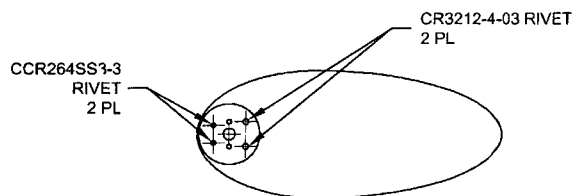
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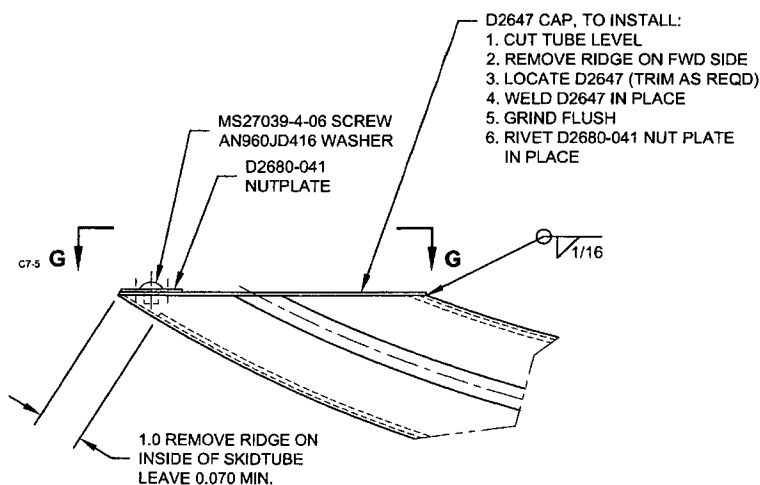
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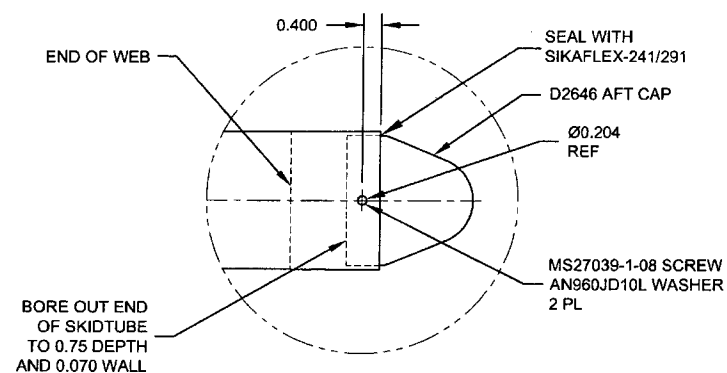
RELEASED
97 03 03



VIEW G-G
SCALE NONE
A7-5



DETAIL E
SCALE NONE
B7-2
B7-3



DETAIL F
SCALE NONE
B2-2
B2-3

DESIGN	97	DART AEROSPACE USA, INC	
DRAWN	97	PORT HADLOCK, WA	
CHECKED	97	DRAWING NO.	REV. A
MFG. APPR.	97	D3804	SHEET 5 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 281

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 77988
Part number: A206-642-151
Description: Skid plate
Welding Process: Tig[☒] Mig[☐]
Base material: Aluminium
Current: AC[☒] DC[☐]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[☐]
Penetration: pass[☒] fail[☐]

UNACCEPTABLE

Cracks: pass[☒] fail[☐]
Undercut: pass[☒] fail[☐]
Pin holes: pass[☒] fail[☐]
Overlap (cold lap): pass[☒] fail[☐]
Porosity (surface): pass[☒] fail[☐]
Coloration: pass[☒] fail[☐]

Qualifier David Nunn Date of Test Coupon 12.01.23
Welder Barclay Elliot Date of Test Coupon 12.01.23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld